

EQUAL DIAMETER METHOD (BEARER CONTACT PRESSES)

This is the most commonly used method where the plate and blanket are each packed to bearer height plus sufficient packing to give the required plate/blanket squeeze pressure to produce the correct image transfer from plate to blanket when clothed. These two cylinders have the same diameter. The additional packing for the required squeeze pressure is divided between the plate and blanket cylinders - if the squeeze pressure is an odd number e.g. .003" (.075mm), then .002" (.5mm) packing is placed under the blanket and .001" (.025mm) under the plate. Where a compressible blanket is used the extra packing recommended **MUST** be placed under the blanket even though technically speaking the diameter would not be equal.

Example for .003" (.075mm) squeeze (conventional).

Plate Cylinder

1. Undercut	.015" (.38mm)
2. Plate thickness	.008" (.20mm)
3. Packing	.008" (.20mm)
4. TOTAL	.016" (.41mm)
5. Height above bearer (4) - (1)	+ .001" (.025mm)

Blanket Cylinder

1. Undercut	.162" (4.1mm)
2. Blanket thickness $2 \times .075"$ (1.9mm)	.150" (3.8mm)
3. Packing	.014" (0.35mm)
4. TOTAL	.164" (4.2mm)
5. Height above bearer (4) - (1)	+ .002" (.05mm)
TOTAL SQUEEZE $+ .002 + .001 =$.003" (.075mm)

NOTE.—This calculation has not taken into account the fact that initial make ready with a *new* blanket should allow for a loss in thickness of .0015" (.038mm) to .002" (.05mm) due to compression of the fibres of the blanket carcass caused by tensioning. Consequently packing of .015" (.38mm) or .016" (.041mm) underneath the underblanket would give an initial squeeze of .004" (.10mm) or .005" (.13mm) which would soon drop to .003" (.075mm) squeeze pressure.

If the top blanket employed is a new compressible blanket this would require .003" (.075mm) to .004" (.10mm) extra packing to compensate for fabric compression and manufacturers specification for compressible blankets.